



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G11631-3G-03

Job Sheet 177274



Part No: RBW6305G11631-3G-03

Job Qty: 10 ea 5

DAS
21
9-89

Part Name: Body



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Template:

Job Tracking No:

Job Created: 5/9/18

Created By: Marie Lajeunesse

Due Date: 5/25/18

Description:

Type: SOLD

Note: DWG RBW6305G11631-3G Rev. D IPP Rev. A 18.05.08 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	5/25/18	5/25/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	10 pcs	5/25/18	5/25/18	0.00	1.25	Bandsaw1		
120	Mori Seiki	10 pcs	5/25/18	5/25/18	0.00	5.00	MORI SL2500Y		
150	QC	10 pcs	5/25/18	5/25/18	0.00	0.00	QC2 Machining-5		
160	QC	10 pcs	5/25/18	5/25/18	0.00	0.00	QC8 Machining-5		
190	Packaging	10 pcs	5/25/18	5/25/18	0.00	0.00	Packaging3-2		
200	QC21-SA	10 Ea	5/25/18	5/25/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks to 4.125" 500

Descriptions: 120 - 1-Machine as per folio FC 096 FOLIO REV: DWG REV: D 2-Debur

190 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-R4.000	AISI 4140 Round Bar	3.5400 ft (.354 ea)	90-Start up Operation	5058924

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-R4.000	4	2	0

4140 QT R4.000

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

5/9/18 11:42 AM Dart.lajeunesse.marie

Container No: S079011



Part: RBW6305G11631-3G-03

Job No: 177274

Serial No/Batch: S079011

Revision:

Inspector:

Exp Date: 06/07/2018

Instructions:

Date: 06/07/18

DQA: _____ Date: _____



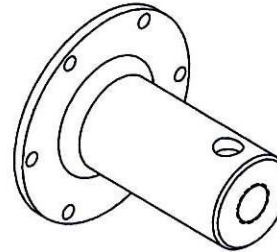
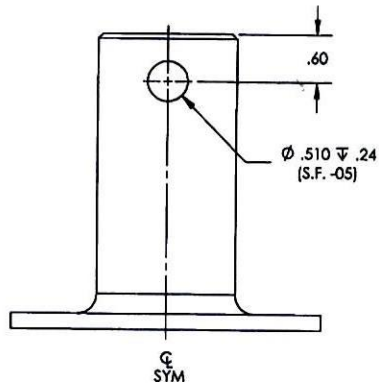
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

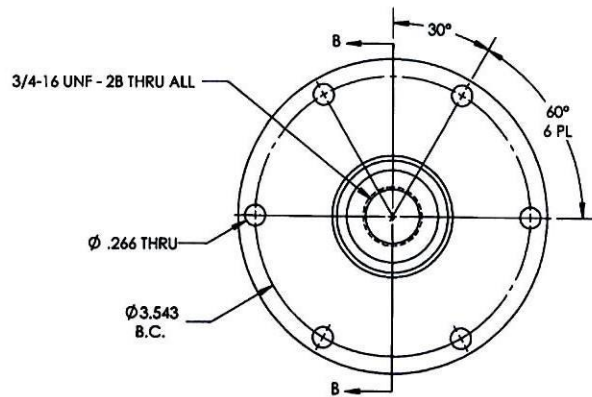
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

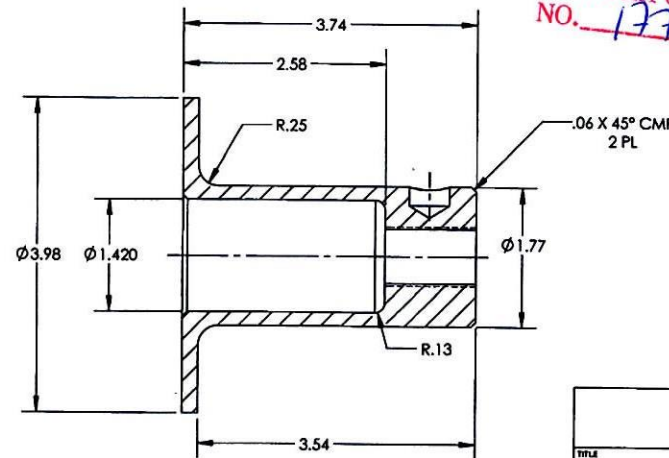
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
D	3.015 B.C. CHANGED FOR 3.543. TEMPLATE UPDATED. DIMENSION .500 CHANGED FOR .510	18-539	18.2.8	VM	ML



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 177274 MJS
1805-05



RBW6305G11631-3G-03 BODY



SECTION B-B

- NOTES:**
1) MATERIAL: AISI 4140/4142 (Rc 28-32)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: N/A

DART AEROSPACE Hawkebury, Ontario, Canada	
TITLE BODY	
PART NO. RBW6305G11631-3G-03	REV D
TOOL NO. RBW6305G11631-3G	
INITIALS AND DATE	
DESIGNED BY: VM 2/8/2018	TOLERANCES: UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET FOR ASS. Y&Z UNLESS SPECIFIED DIMENSIONS APPLY AFTER FINISHING
DRAWN BY: VM 02/09/2018	XXX ± .005
CHECKED BY: VM 02/09/2018	XX ± .01
MFG REVIEW BY: DD 02/13/2018	X ± .1
APPROVED BY: ML 04/24/2018	SCALE: NTS
SHEET 3 OF 6	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					